

Need for Mon 19/09/11

Work Order ID 73812

Friday, September 16, 2011 10:12:43 AM



Item ID: D2534

Accept



Setup Start



Revision ID:

Stop



Item Name: Lock Plate

Start Date: 9/16/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/19/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2534

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2734 ☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-
Deburr if necessary

B11-9-19

[Signature]

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-9-19

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/16/19

Count
446

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 73812

Friday, September 16, 2011 10:12:43 AM



Page 2

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Process Plan:

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: WA

0.00

PC 11-09-22

(x46)

AMB

11/09/22

Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

140

QC21- Final Inspection - Work Order Release

0.00

11/9/27 AG

QC

Memo

0.00

Quality Control

11-09-22
(HG)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 10:12:40 AM

Page 1

Work Order ID: 73812

Parent Item: D2534

Parent Item Name: Lock Plate



Start Date: 9/16/2011

Required Date: 9/19/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev:B Now on Waterjet 06-06-20 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S11GA

Purchased

No

110

sf

25.0000

0.0427

1.348421

2,



B119-19

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

25

117494

25

117494

46

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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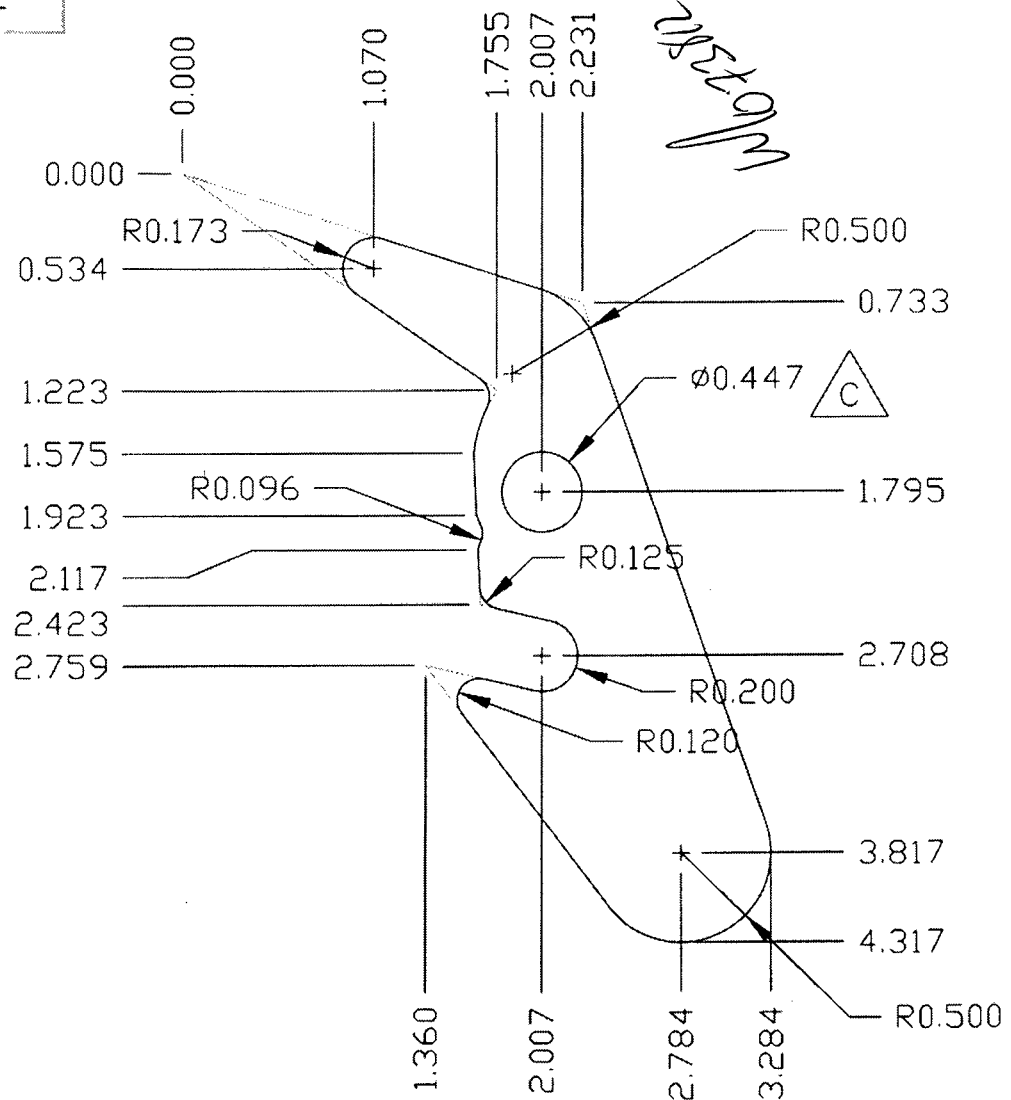
NOTE: Date & initial all entries



| | | | |
|----------------------------|-----------------------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| B WILLIAMS | PH | DRAWING NO. D2534 | REV. 0 |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | SHEET 1 OF 1 | |
| DATE 04.12.14 | TITLE LOCK PLATE | | SCALE 1:1 |
| C | 96.07.26 | HOLE WAS 0.328 | |
| D | 04.12.14 | UPDATE NOTES | |

RELEASED

04.12.16 *[Signature]*



D2534 LOCK PLATE

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NOTE: Date & initial all entries

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|--------------------------------|---------------|---------------------|-------|
| DART AEROSPACE LTD | | Work Order: | 43812 |
| Description: Lock Plate | | Part Number: | D2534 |
| Inspection Dwg: D2534 | Rev: D | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

| W/O: | | WORK ORDER CHANGES | | | | | |
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